

Work Order ID 144470

April 19, 2016 9:56:50 AM

144470

Page 1

Item ID: D350-794-141

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Tank Assembly

Start Date: 5/13/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/30/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: SJA

Date: 20160419

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D350-794

G

MW 1605-09

100

Document Control

0.00

DAS

6

9-89

MAY 06 2016

DAS

28

9-89

MAY 18 2016

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-794-141

CHG004

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS

27

9-89

DAS

6

9-89

MAY 06 2016

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.03

Quality Control

DAS

28

9-89

MAY 18 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Work-Order ID 144470

April 19, 2016 9:56:50 AM

144470

Page 2

Item ID: D350-794-141

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tank Assembly

Start Date: 5/13/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/30/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-794-141								
	Location:								
	PPP Rev: <u>144468</u>								
140		0.00							
140	QC21- Final Inspection - Work Order Release								
QC	Memo	0.10							
Quality Control									

DAS
28
9-89
MAY 18 2016MCS
MAY 18 2016MCS
MAY 18 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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April 19, 2016 9:56:55 AM

144470

D350-794-141

Required Date: 5/30/2016

Required Qty: 1.00

IPP REV:B
IPP REV:C 15.01.15 as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4464-041		Manufactured	No			110	Each	0.0000	1	1			
D4464-041									**				DAS 27 9-89
Fuel Tank Assembly													
D4002-041		Manufactured	No			110	Each	6.0000	1	1			
D4002-041									**				DAS 27 9-89
Aux Tank Drain Hose Assy, Fwd													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST211		6							
					116043	4							
					139225	2							
D4002-043		Manufactured	No			110	Each	7.0000	1	1			
D4002-043									**				DAS 27 9-89
Aux Tank Drain Hose Assy, Aft													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST211		7							
					121180	3							
					130064	2							
					143794	2							
MS20822-3D		Purchased	No			110	Each	7.0000	2	2			
MS20822-3D									**				DAS 27 9-89
Elbow													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST304		7							
					m132552	2							
					m133284	5							

MAY 06 2016

Picklist Print

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Page 2

Work Order ID: 144470

144470

Parent Item: D350-794-141

D350-794-141

Parent Item Name: Tank Assembly

Start Date: 5/13/2016

Required Date: 5/30/2016

Start Qty: 1.00

Required Qty: 1.00

AN816-6D	Purchased	No	110	Each	6.0000	1	1		
AN816-6D									
Nipple-M-6Flare -1/4NPT									

**

DAS
27
9-89

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST325	6					
			M129913	2					
			M132767	4					
MS20822-8D	Purchased	No	110	Each	5.0000	1	1		
MS20822-8D									
ELBOW									

**

DAS
27
9-89

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST304	5					
			m130325	1					
			m133577	4					
D4009-041	Manufactured	No	110	Each	7.0000	2	2		
D4009-041									
Bonding Braid									

**

DAS
27
9-89

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST071	7					
			120121	1					
			137081	6					
D4008-041	Manufactured	No	110	Each	16.0000	1	1		
D4008-041									
Fuel Filler Splash Guard Assembly									

**

DAS
27
9-89

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST243	16					
			137305	16					
TBA28B	Purchased	No	110	Each	0.0000	3	3		
TRA28B									
CABLE TIE FASTENER use D3600-1									

**

DAS
27
9-89

134740

April 19, 2016 9:56:55 AM

Shop Packet Print

MAY 16 2016

Picklist Print

April 19, 2016 9:56:55 AM

Work Order ID: 144470
Parent Item: D350-794-141
Parent Item Name: Tank Assembly

144470
D350-794-141

Start Date: 5/13/2016 Required Date: 5/30/2016
Start Qty: 1.00 Required Qty: 1.00

TY25MX Purchased No 110 Each 841.0000 1 1

TY25MX
TIE WRAP

**

DAS
27
9-89
6
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
st572	841	
115695	841	

DAS
28
9-89

MAY 06 2016

Qty -111	Qty -013	Qty -121	Qty -023	Qty -141	Part Number	Superseded Part Numbers	Description
X					D350-794-111		AUXILIARY FUEL TANK (AS 350 SERIES)
1	X				D350-794-013		AUXILIARY FUEL TANK PROVISIONS (AS 350 SERIES)
		X			D130-794-121		AUXILIARY FUEL TANK (EC 130 SERIES)
		1	X		D130-794-023		AUXILIARY FUEL TANK PROVISIONS (EC 130 SERIES)
1		1		X	D350-794-141		TANK ASSEMBLY
				1	D4464-041		TANK ASSEMBLY
	1		1		D4022-041	A8150-B1-JCA	FUEL TRANSFER PUMP ASSEMBLY
				1*	D4023-3		FUEL CAP
	1		1		D4002-5	JCA-M47-2-13	SUPPLY HOSE – FROM AUX TANK
	1		1		D4003-047	JCA-M47-2-16	FUEL PUMP INLET PIPE
	1		1		D4002-7	JCA-M47-2-25	SUPPLY HOSE – PUMP TO MAIN TANK FILLER NECK
				1	D4002-041	JCA-M47-1-13	DRAIN HOSE ASSEMBLY – FRONT
				1	D4002-043	JCA-M47-1-16	DRAIN HOSE ASSEMBLY – REAR
				2	MS20822-3D		UNION
	1		1		AN832-6D		BULKHEAD UNION
				1	AN816-6D		STRAIGHT FITTING
	2		2		AN924-6D		NUT (ALTERNATE AS5178D06)
	2		2		NAS1149D0963J		WASHER
				1	MS20822-8D		90° FITTING
	2		2		AN815-6D		UNION
	2		2		MS29512-06		ORING
	1		1		D4022-3	05-00021	FUEL PUMP MOUNTING BRACKET
	2		2		AN3-4A		BOLT
	2		2		MS21042-3		NUT
	2		2		AN970-3		WASHER
	1		1		D4008-043	JCA-M47-2-29	FUEL PUMP SPLASH GUARD
	1		1		D4004-7	N3	HOSE CLIP
				2	D4009-041	JCA-M47-4-01	BONDING BRAID
				1	D4008-041	JCA-M47-2-26	AUXILIARY TANK FILLER SPLASH GUARD
	4		4		AN525-10R6		SCREW
	1		1		D4001-3	AN832-6D-JCA	BULKHEAD FITTING – MODIFIED
							VENT ASSEMBLY PARTS
	2		2		MS21919WDG-8		CLAMP
	1		1		D4003-11	JCA-M47-2-21	VENT PIPE – TANK
			1		D4027-041	JCA-M47-2-20	VENT CLAMP ASSEMBLY
	1		1		D4003-049	JCA-M47-2-17	VENT PIPE – TANK
	1		1		D4027-043	JCA-M47-2-35	VENT CLAMP ASSEMBLY
	1		1		D4063-3	193-8	VENT HOSE
	2		2		2000-8S		HOSE CLAMP
	1		1		NAS43DD3-32N		SPACER
	1		1		MS35207-267		SCREW
	2		2		MS35207-264		SCREW
	3		3		NAS1149D0332J		WASHER
	3		3		MS21042-3		NUT
				3	TBA28B		CABLE TIE FASTENER
				1	TY25MX		TIE WRAP
	1		1		MS21919WDG-6		CLAMP (RUBBER REMOVED)
	1		1		D4009-041	JCA-M47-4-01	BONDING BRAID ASSEMBLY

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Revision: **G**

Date: 14.08.20

Qty -111	Qty -013	Qty -121	Qty -023	Qty -141	Part Number	Superseded Part Numbers	Description
							Restraint Assembly Parts
	1		1		D4005-1	JCA-M47-2-03	REAR RESTRAINT ANGLE/GUTTER
	1		1		D4004-11	JCA-M47-2-11	TOP STRAP ATTACH BRACKET
	1		1		D4004-5	JCA-M47-2-23	BOTTOM STRAP ATTACH BRACKET
	3		3		MS24694-S50		SCREW
	3		3		MS21042-3		NUT
	3		3		NAS1149F0363P		WASHER
	1		1		D4024-041	JCA/ASSO/MIN	ANCRA RESTRAINT STRAP
	1		1		D4004-041	JCA-M47-2-19	SIDE RESTRAINT ANGLE
	1		1		D4007-3	JCA-M47-2-18	TOP SUPPORT BRACKET
	1		1		D4006-041	JCA-M47-2-01	TANK TOP SUPPORT ASSEMBLY
	2		2		AN4-5A		BOLT
	2		2		NAS1149F0463P		WASHER
							LOCKER PREPARATION PARTS
	1		1		D4005-041	JCA-M47-2-22	FORWARD FLOOR GUTTER
	1		1		D4063-1	193-6	DRAIN HOSE
	1		1		MS21919WDG-9		CLAMP
	1		1		MS35207-264		SCREW
	1		1		NAS1149D0332J		WASHER
	1		1		MS21042-3		NUT
	1		1		2000-6S		HOSE CLAMP
	3		3		NAS1474-08		SEALED CAPTIVE ANCHOR NUT
	1		1		D4005-11	JCA-M47-2-12	FINISHING STRIP
	4		4		MS21059-L08		ANCHOR NUT
	7		7		AN525-832R6		SCREW
							Electrical Parts
	1		1		D4290-9	D8-603 (ALT. HA23-6U3)	6.3A ECF FUSE
	1		1		D4290-11	D1-205 (ALT. HA21-2U5)	2.5A ECF FUSE
	1		1		MS35058-23		SWITCH
	1		1		D4290-29	107-964	CONNECTOR RECEPTACLE
	1		1		D4290-27	107-978 (ALT. 105-5465)	CONNECTOR BACKSHELL
	1		1		D4290-25	107-943	CONNECTOR PLUG
				1*	D4025-5		FUEL QUANTITY SENDER
	4		4		MS35206-217		SCREW
	4		4		NAS1149FN416P		WASHER
	4		4		MS21044N04		NUT
	1		1		D4290-33	143-207	PLUG
	1		1		D4290-23	143-208	RECEPTACLE
	1		1		D4290-15	143-204 (ALT. 973-1482)	RECEPTACLE HOUSING
	1		1		D4290-17	143-203 (ALT. 973-1490)	PLUG HOUSING
	5		5		D4290-35	143-219 (ALT. 977-3800)	CRIMP PIN
	5		5		D4290-31	143-217 (ALT. 977-3797)	CRIMP SOCKET
	1		1		D4009-041	JCA-M47-4-01	BONDING BRAID ASSEMBLY
	1		1		D4026-041	FL-100-R-JCA	FUEL GAUGE
	2		2		AN525-832R6		SCREW - GROUND STUD
	2		2		NAS1149FN832P		WASHER

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Revision: **G**
Date: 14.08.20

Qty -111	Qty -013	Qty -121	Qty -023	Qty -141	Part Number	Superseded Part Numbers	Description
	2		2		MS21042-08		NUT
	1		1		D4290-7	444-2556	GAUGE MASTER SWITCH
	1**		1**		D4022-5	3775628 (ALT. 100-6847)	THERMAL SWITCH (125°C) – FARNELL
							GENERAL
	1		1		AN5800-1		PLACARD HOLDER
	1		1		AN929-6D		BLANK CAP
				1*	D4968-1		CUSHION
							ADDITIONAL EC 130 PARTS
			3		MS35207-264		SCREW
			3		NAS1149D0332J		WASHER
			3		MS21042-3		NUT
			1		D4027-041	JCA-M47-2-20	VENT CLAMP ASSEMBLY
			1		D4004-043	JCA-M47-2-04	SIDE RESTRAINT ANGLE AND TIE DOWN POINT
			1		D4005-5	JCA-M47-2-06	ANGLE
			4		D4005-7	JCA-M47-2-07	ANGLE
			1		D4005-9	JCA-M47-2-08	ANGLE
			1		D4007-1	JCA-M47-2-02	TOP SUPPORT BRACKET
			1		D4005-3	JCA-M47-2-05	FORWARD RESTRAINT BEAM
			2		AN4-6A		BOLT
			1		D4007-5	JCA-M47-2-24	PACKER
							PLACARDS
	1				D3997-1	JCA-M47-P1	FUEL QUANTITY – AS 350 MODELS
			1		D3997-3	JCA-M47-P2	FUEL QUANTITY – EC 130 B4 MODEL
				2*	D3997-5	JCA-M47-P3	AUX FUEL DRAIN
	1		1		D3997-7	JCA-M47-P4	AUX FUEL TRANSFER PUMP
	1		1		D3997-9	JCA-M47-P5	AUX FUEL
				1*	D3997-11	JCA-M47-P6	WEIGHT AND BALANCE
	1		1		D3997-13	JCA-M47-P7	ON/OFF
	1		1		D3997-15	JCA-M47-P8	CHECK LOCKER TANK
				1*	D3997-17	JCA-M47-P9	STOWAGE PROHIBITED
	1		1		D3997-19	JCA-M47-P10	TANK VENT
	1		1		D3997-21	JCA-M47-P13	SWITCH FIXED
	1		1		D3997-23	JCA-M47-P14	AUX FUEL
	1				D3997-25	JCA-M47-P15	CONVERSION CHART – AS 350 MODELS
			1		D3997-27	JCA-M47-P16	CONVERSION CHART – EC 130 B4 MODEL
				1*	D3997-29	JCA-M47-P17	DO NOT OVERFILL WARNING
	1		1		D3997-31	JCA-M47-P18	ON/OFF
	1		1		D3997-33	JCA-M47-P19	AUX GAUGE FACE
	1		1		D3997-35	JCA-M47-P20	AUX FUEL GAUGE
	1		1		D3997-37	JCA-M47-P21	6.3 A CIRCUIT BREAKER
	1		1		D3997-39	JCA-M47-P22	2.5A CIRCUIT BREAKER
	1		1		D3997-41	JCA-M47-P23	AUX TANK NOT FITTED
				1*	D3997-43	JCA-M47-P24	EARTH

* - items included as part of D4464-041 tank assembly

** - items included as part of D4022-041 pump assembly